

Work Order ID 83712

April-24-12 10:45:25 AM

83712

Page 1

Item ID: D2564

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Mounting Angle

Start Date: 24/04/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 01/05/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/24

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2564

Rev B1

100

0.00

100

BAND SAW

12-4-25

20

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut D6207 Extrusion: 1.00" Long (+0.000/-0.030)

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

12-4-25

20

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Echo FA276 Rev: _____ & Dwg D2564 Rev: _____

2-Debur if necessary

Manual

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

12-4-25

20

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Tooling:

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Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: <u>W14</u>	0.00							
140									
Packaging	Memo	0.00							
Packaging	*** STOCK IN STEP CELL***								
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

12/4/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

April-24-12 10:45:30 AM

Page 1

Work Order ID: 83712

83712

Parent Item: D2564

D2564

Parent Item Name: Mounting Angle

Start Date: 24/04/2012

Required Date: 01/05/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: D02.09.09Re-format; Added FA276 FolioKJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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~~MS20257P5-7200~~

Purchased

No

0.0000

1

~~MS20257P5-7200~~

**

Piano Hinge

De207 12.04.30
MAT028

18.3343 B 72237

.0916f

2.0f 12-4-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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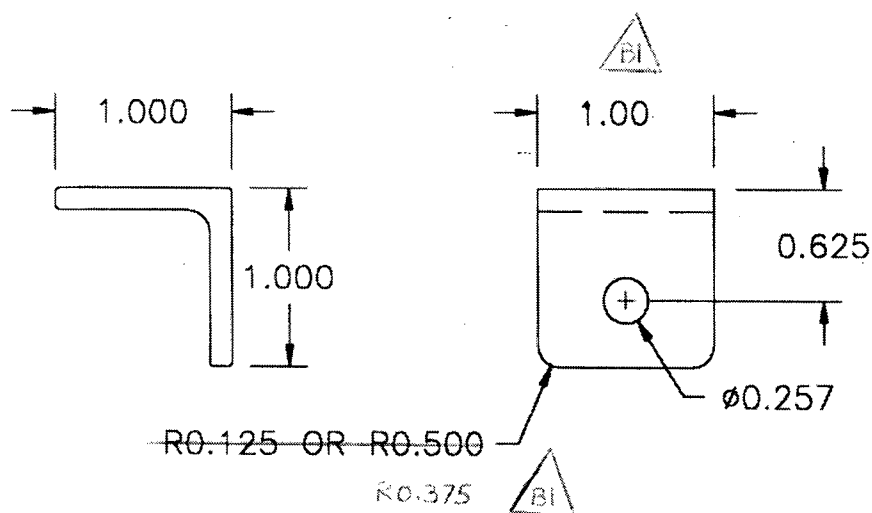
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DESIGN		DRAWN BY		DART AEROSPACE LTD	
MIKE M		MIKE M		VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED		APPROVED		DRAWING NO.	
BW		BW		D2564	
DATE		TITLE		REV. B	
96:04:30		MOUNTING ANGLE		SHEET 1 OF 1	
B		97:05:06		SCALE	
BI		02.07.17		1:1	
				MODIFIED DIMENSIONS	
				R0.375 WAS R0.125 OR R0.500 ;	
				1.00 WAS 1.000	

RELEASED
97/05/06 BW



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83912
12/04/24
MCJ

NOTES

- 1) MATERIAL: 6061-T6 ANGLE 1.0 X 1.0 X 0.125
MAKE FROM D6207-XXX ANGLE EXTRUSION
- 2) BREAK ALL SHARP EDGES 0.005 R0.015
- 3) TOLERANCES PER DART 631 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

Dart Aerospace Ltd

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NOTE: Date & initial all entries

Item ID: D2564

POM Extrusion Production																													
Status	Item ID	Rev	Name	Start Date	Quantity	UOM	Op Date	Seq	Crp	ap	Quar	mm	ind	Nt	C	IL	Sortime	Offset	an	Ty	1	Per	Orrch	to	Viore	Cte	Last	Mdd	Date
	D6207		Angle Extrusion	12/05/09	0.0...	f		100	5 %	0.0000						0		0	MRP	<input type="checkbox"/>						12/0...	12/0...		